

Work Order ID 72902

Wednesday, August 17, 2011 2:48:18 PM

Page 1

Item ID: D4306-044

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly, RH

Start Date: 8/17/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4306

C

100

Weld per dwg A/R S.S. rod Batch: 1120013 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut tube 52"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size and cut notch as per dwg D4306-4
- 4- Drill and chamfer holes as per dwg D4306-4 using DT9710
- 5- weld bushing as per dwg D4306
- 6- grind welds flush

SAD
12-05-17

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

2x of Cpl 12-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72902

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Page 2

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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

2X ϕ PL 12.05.19

130

Identify as per dwg & Stock Location: **WA**

0.00

Packaging

Memo

0.00

Packaging

2X PL 12.05.19

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

12/5/22

MF 12-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:48:23 PM

Page 1

Work Order ID: 72902

Parent Item: D4306-044

Parent Item Name: Rib Assembly, RH

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	253.0000	4	4			
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Bushing

Location

Loc Qty

Loc Code

WA	251	
69202	51	
72316	200	
WA005	2	
66489	2	

B32785

8

M304TS0.750W.049

Purchased

No

100

f

386.2431

4.166

4.385263



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018	285.487909	
117690	4.372109	
117775	98.4265	
118472	182.6893	
MAT034	1.8507	
117337	1.8507	
WA	98.90454	
118184	98.90454	

B12108

8.7706

SAD 12-05-17

SAD 12-05-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

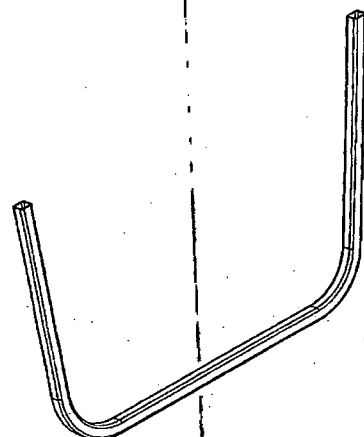
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

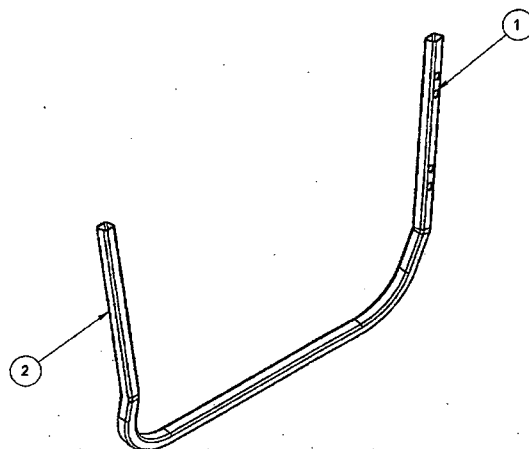
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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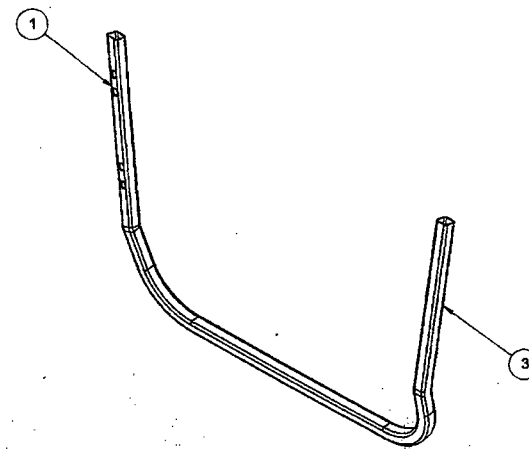
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



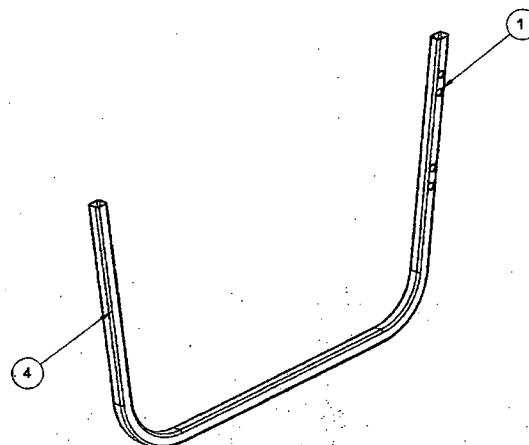
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



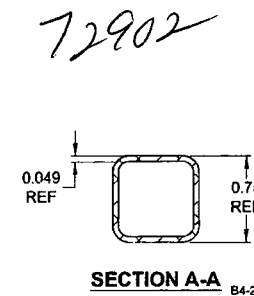
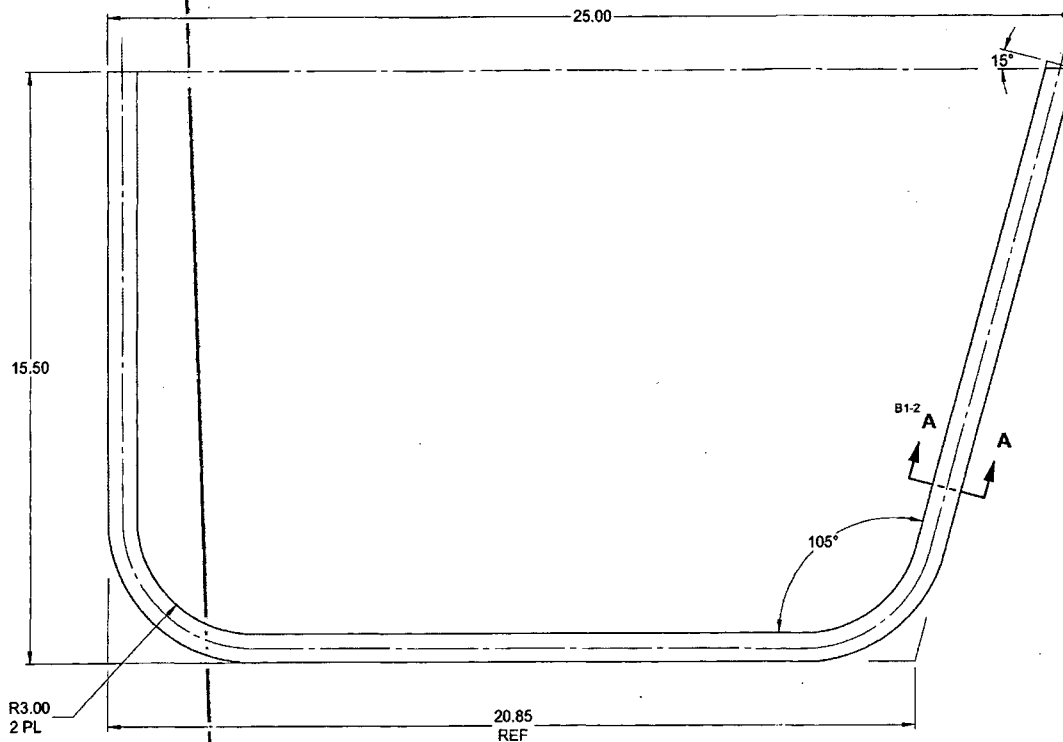
D4306-045 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72902

RE 11-08-17

RELEASED
2011-03-10

C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-8); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.85" (C7-4, C8-4, C1-5, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B6-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4306	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
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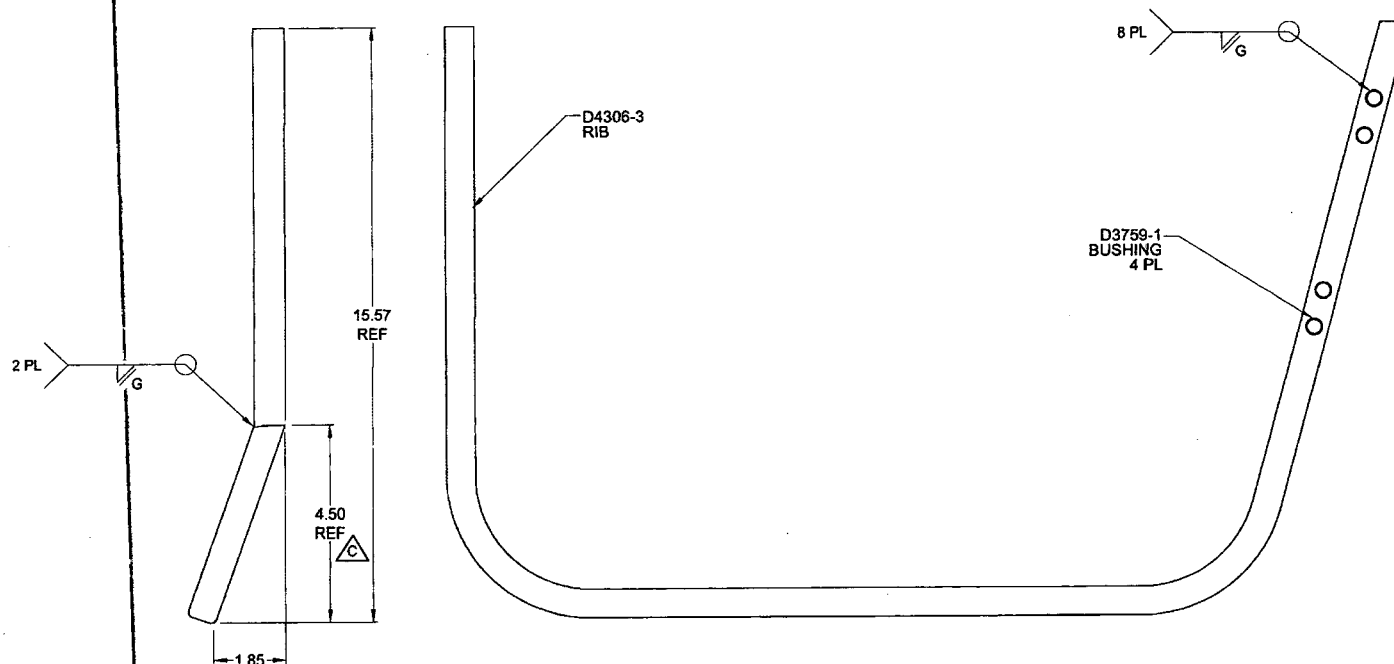


RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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D4306-043 RIB ASSY, LH

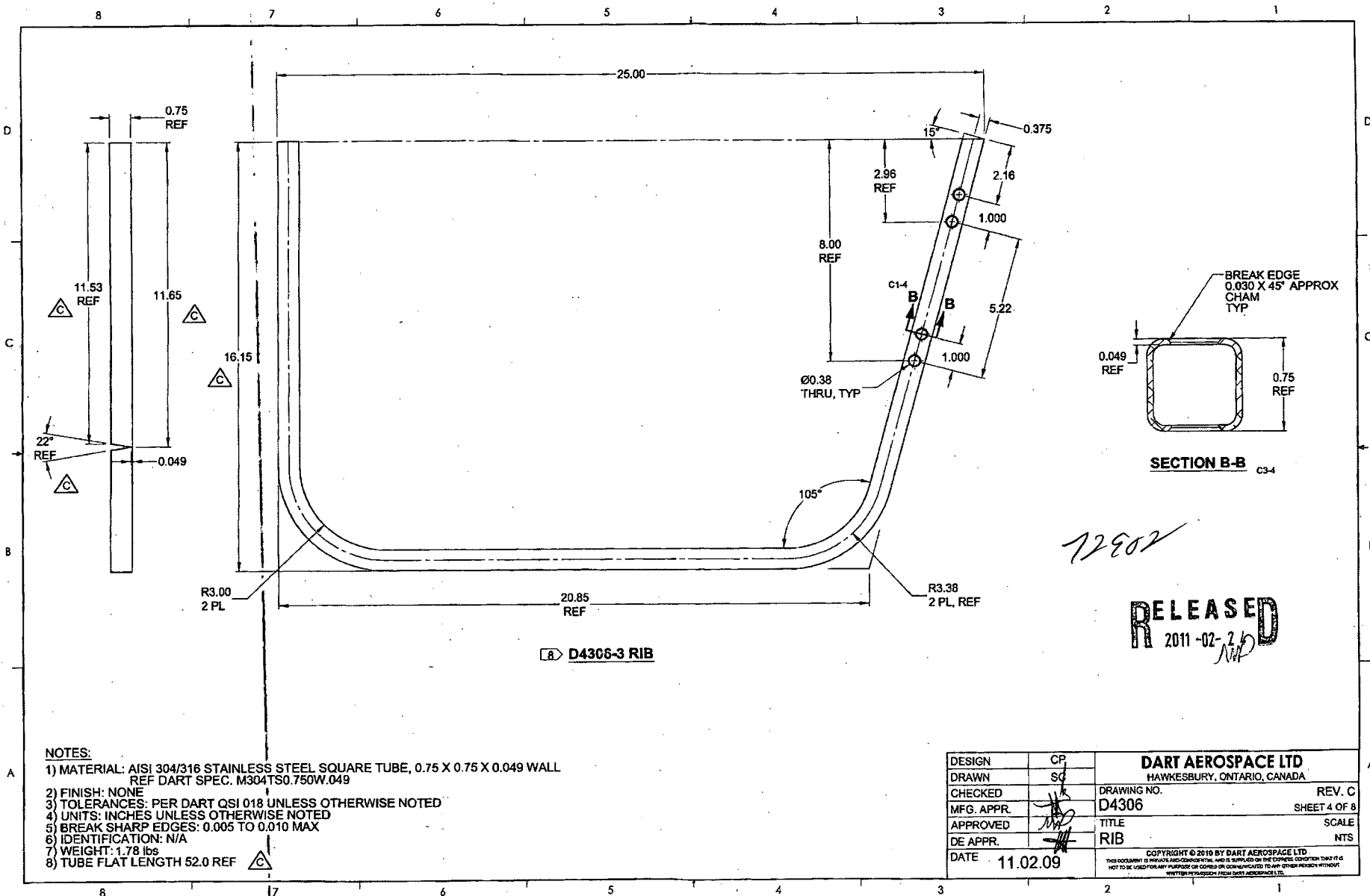
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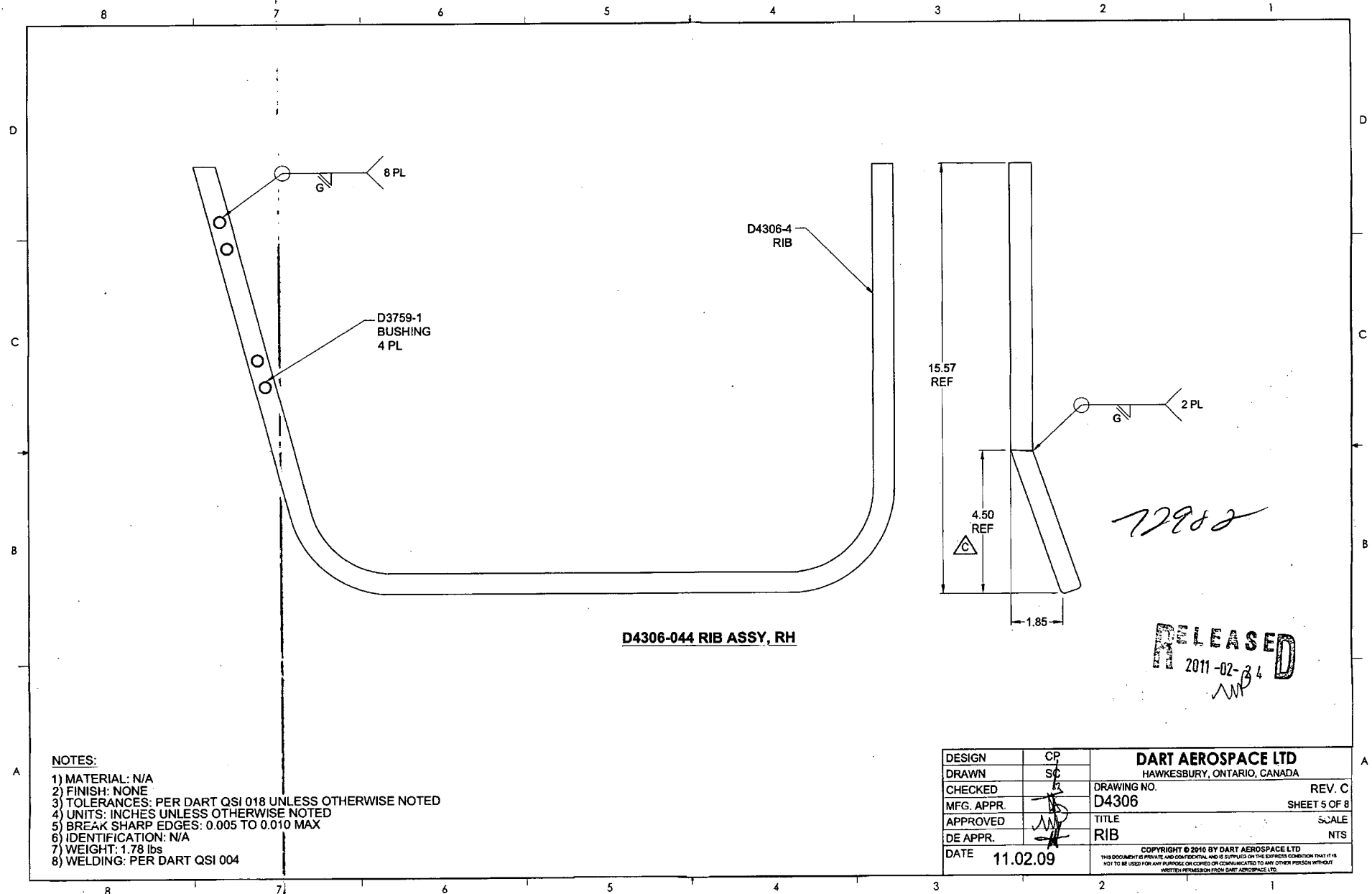
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

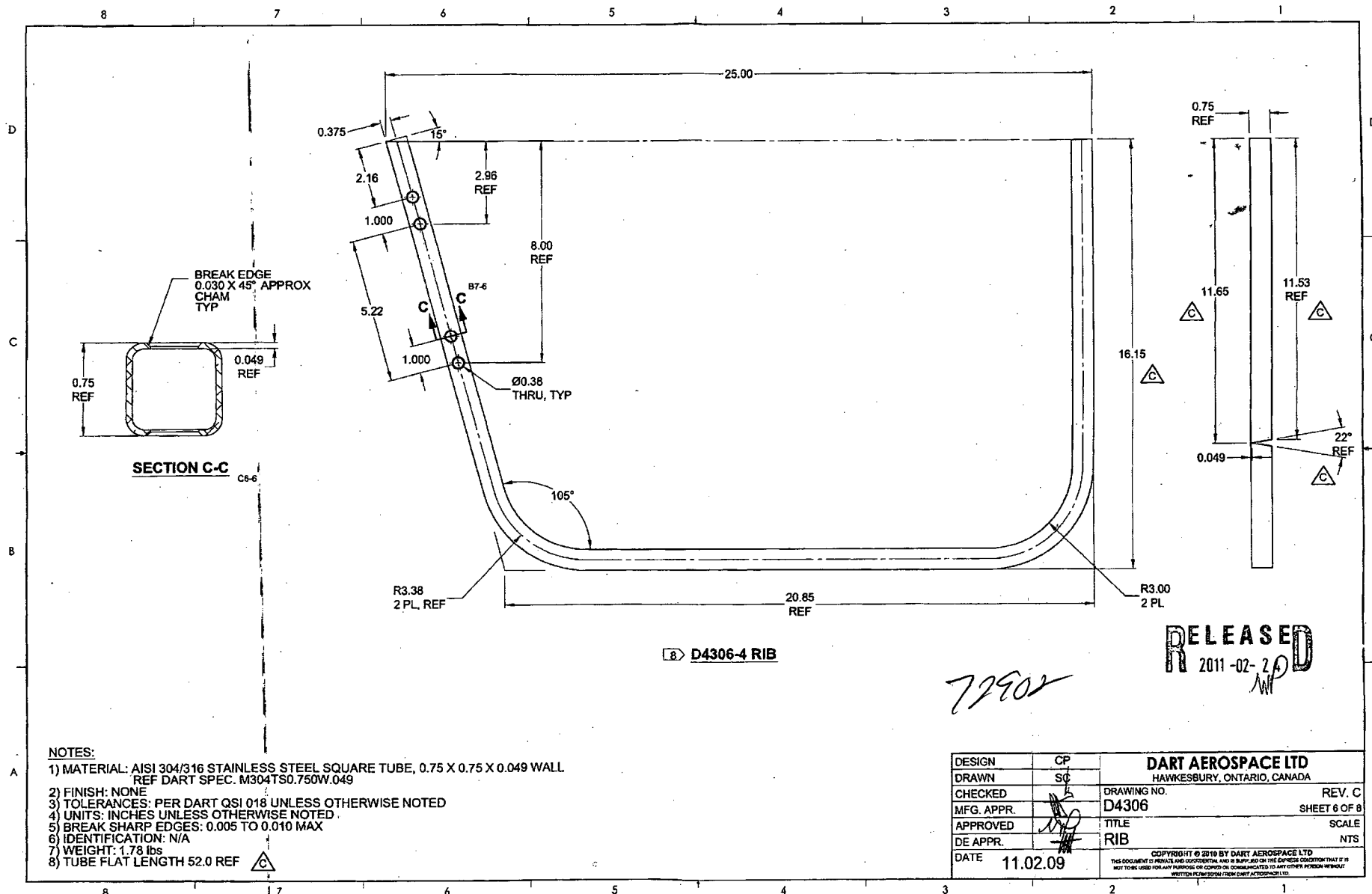
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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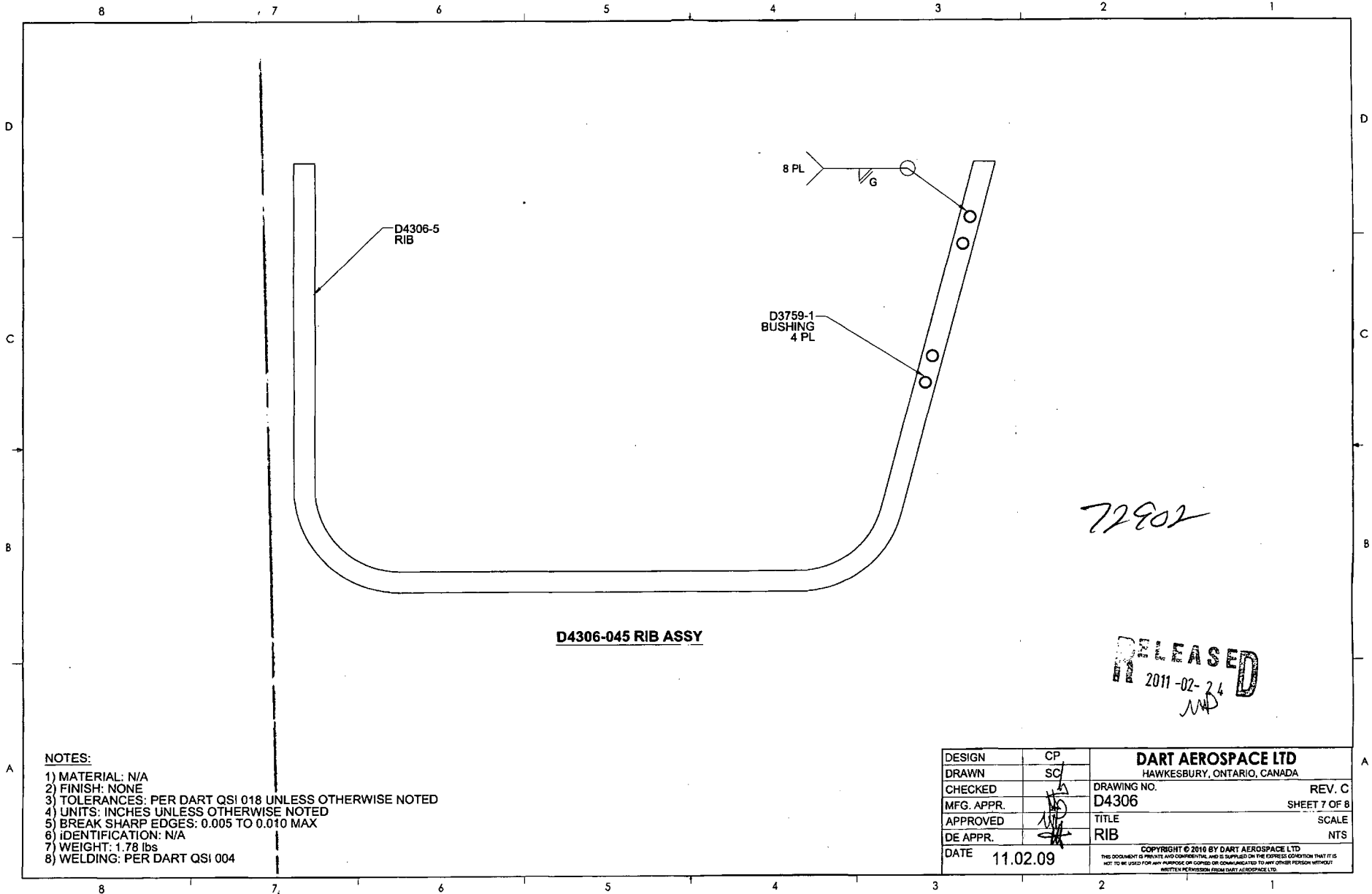
RELEASED
2011-02-24
MB

72902









NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
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